



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2432**Job Sheet 213682****Part No:** D2432**Job Qty:** 20 pcs**Part Name:** Bearpaw 19" X 24"**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 10/1/20**Job Tracking No:****Due Date:** 11/30/20**Created By:** Marie Lajeunesse**Type:** Stock**Description:****Note:** DWG REV H IPP REV:A 12.10.17 AS PER DWG REV.H DD VERF:JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
120	Waterjet - Omax - 1	20 pcs	11/27/20	11/27/20	0.17	5.15	Waterjet - Omax	on 20/10/19
130	HAAS 4 Axis - B4B	20 pcs	11/30/20		1.00	25.03	HAAS - 1 - B4B	
							HAAS - 2 - B4B	
							HAAS - 3 - B4B	DIP 20-11-24
							HAAS - 4 - B4B	
140	QC 2	20 pcs	11/30/20		0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	

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150 QC 8	20 pcs	11/30/20	0.00 0.00	QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	DIP 20-11-28
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
160 Packaging 3-1 - Stock - B4B 20 pcs ✓		11/30/20	0.00 0.00	QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	A.e 20-11-29
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	NOV 30 2020 80
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	ST260B 9-89
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	

					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
170 QC 21 - SA	20 pcs	11/30/20	0.00	0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
					QC 21 - SA - 9	9-88
					QC 21 - SA - 77	
					QC 21 - SA - 28	
Part Op 120 - Waterjet 2 OMAX (Waterjet 2) Cut Blank as per D2432 File Descriptions: 130 - (HAAS CNC vertical machine #1) 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr 140 - (QC2- Inspect parts off machine FAI/FAIB) 150 - (QC8- Inspect parts - second check) 160 - (Identify as per dwg & Stock Location: _____) 170 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	74 sf (3.7 ea)	120-Waterjet - Omax - 1		5262/28 5235828	
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
120-Waterjet - Omax - 1	MUHMWB10	74	541	0		
Part Specifications						
Specifications could not be found.						

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DART AEROSPACE LTD		Work Order: 213682
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432	Rev: H	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.06 x 45°	✓		Vern.	DIP-05
B	0.200	+/-0.030	0.200	✓		Depth Gage	DIP-04
C	0.25 x 45°	+/-0.030	0.250 x 45°	✓		Vern.	DIP-05
D	R0.250	+/-0.030	0.250	✓		Rad. Gage	REF
E	0.250	+/-0.010	0.250	✓		Vern.	DIP-05
F	0.625	+/-0.030	0.625	✓		"	"
G	0.375	+0.030/-0.010	0.390	✓		"	"
H	0.950	+/-0.030	0.964	✓		"	"
I	19.000	+/-0.030	19.000	✓		REF	Tape / REF
J	Ø0.260	+0.005/-0.000	0.260	✓		Vern	DIP-05
K	Ø0.93	+/-0.030	0.930	✓		"	"
L	0.30	+0.030/-0.000	0.308	✓		Depth Gage	DIP-04
M	23.750	+/-0.030	23.750	✓		Tape	REF
N	2.000	+/-0.030	2.018	✓		Vern.	DIP-05
O	0.38	+/-0.030	0.380	✓		"	"
P							
Q							
R							
S							
T							
U							
V							

Measured by: DIP	Audited by: Ba	Preliminary Approval:
Date: 20-11-24	Date: 20-11-29	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	
E	15.02.09	Dimensions revised	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S307256



Part: D2432

Job No: 213682

Serial No/Batch: S307256

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.

1270 Aberdeen Street

Hawkesbury, ON K6A 1K7

CANADA

TEL: 1 813 632-5200

Email: sales@dartaero.com

www.dartaerospace.com

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